

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002667**Date Inspected:** 03-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:****Deck Panel Repairs**

This Quality Assurance (QA) inspector arrived at ZPMC for observation of the SAS super structure fabrication. During this QA inspectors observation ZPMC was grinding under fill areas and blending them into the closed rib material to remove the defected locations. This QA noted that ZPMC performed a Magnetic Particle (MT) inspection on several locations (28) that had been excavated by grinding to ensure soundness and removal of defects on DP050-001. Welder Zhao Cheng Shuang was observed performing welding repairs with the Flux Cored Arc Welding (FCAW) process according to WPS-345-FCAW-2G (2F)-Repair-1 with welding parameters being monitored by CWI Chen Xi and assistant Quality Control (QC) personnel to ensure that welding parameters were within the tolerances of the WPS stated above. These deck panels do not appear to be completed with the repair process at this time and are in process.

Summary of Conversations:

No Conversations noted.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Pat Lowry (858) 344-2712, who represents the Office of Structural Materials for your project.

Inspected By: Riley,Ken

Quality Assurance Inspector

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Reviewed By: Carreon,Albert

QA Reviewer